

Work Order ID 64367

December 2, 2010 2:52:47 PM

ASAP Monday Dec 6



Item ID: D3339-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad Center

Start Date: 12/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3339

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3339
Deburr if necessary

Dwg Rev: B Prog Rev: B 2-

B10-12-2

(14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-12-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/12/03

(14)

Work Order ID 64367

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Page 2

Item ID: D3339-3

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Setup Start



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Stop



Item Name: Wearpad Center

Start Date: 12/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Deburr if necessary: 2-Form as per Dwg D3339 using DT8326 and DT8261

SPB 10/12/06

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/12/06

4/40

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld Hard coat 7560 per Dwg D3339,use DT8210 & DT8810 Layout
Jig A/R 7560 Hardcoat Batch: M115552

EZ 10-12-06

4/4

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Item Name: Wearpad Center

Start Date: 12/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10-Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:20

OVEN TEMPERATURE:

3200 FINISH TIME:

10:50

180

QC3- Inspect Part Finish

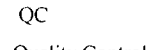
0.00

QC

Memo

0.00

Quality Control



8.012/06



14 BL 10-12-6.

=> 10/12/06

14 Ø

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Item ID: D3339-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad Center

Start Date: 12/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location:

997A

0.00



Packaging

Memo

0.00

Packaging

10/12/10 (14)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/07

10/12/06

Picklist Print

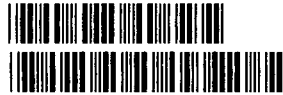
December 2, 2010 2:57:24 PM

Page 1

Work Order ID: 64367

Parent Item: D3339-3

Parent Item Name: Wearpad Center



Start Date: 12/02/10

Required Date: 12/06/10

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

sf

86.5250

0.1

1



1010/1025 sheet 16GA



HB10-12-2

Location

Loc Qty

Loc Code

MAT19

86.525

111410

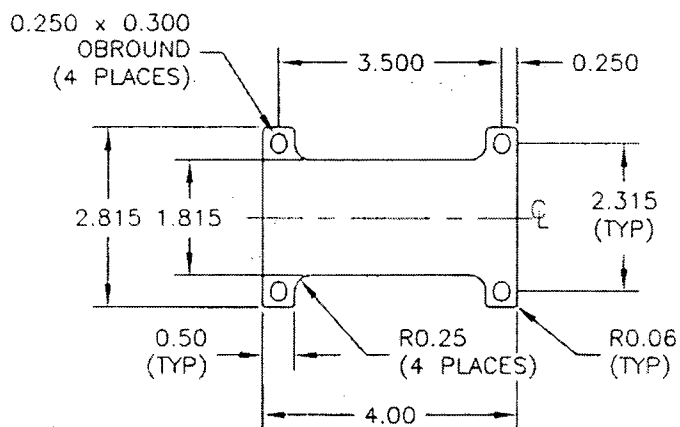
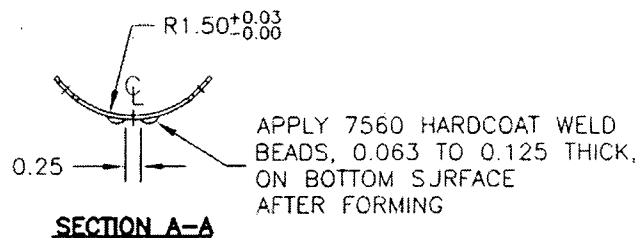
86.525

111410

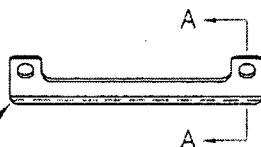
(14)

DART**RELEASED**
05-11-22

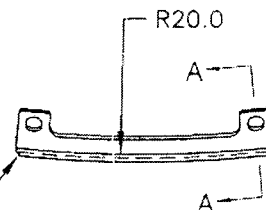
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	

**D3339-1F FLAT PATTERN****SECTION A-A**

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-3T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-3 CENTER WEARPAD**
(MADE FROM D3339-1F)

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-5T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-5 FORWARD WEARPAD**
(MADE FROM D3339-1F)**D3339-1F/-3/-5 WEARPAD****NOTES:**

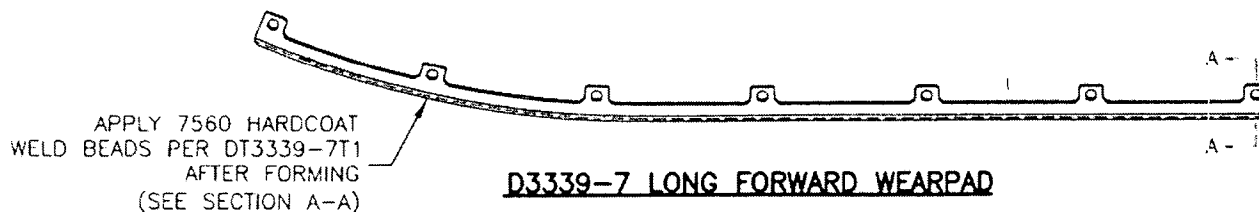
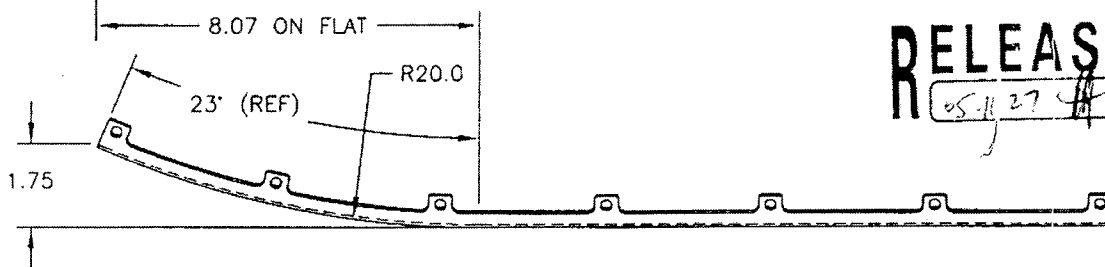
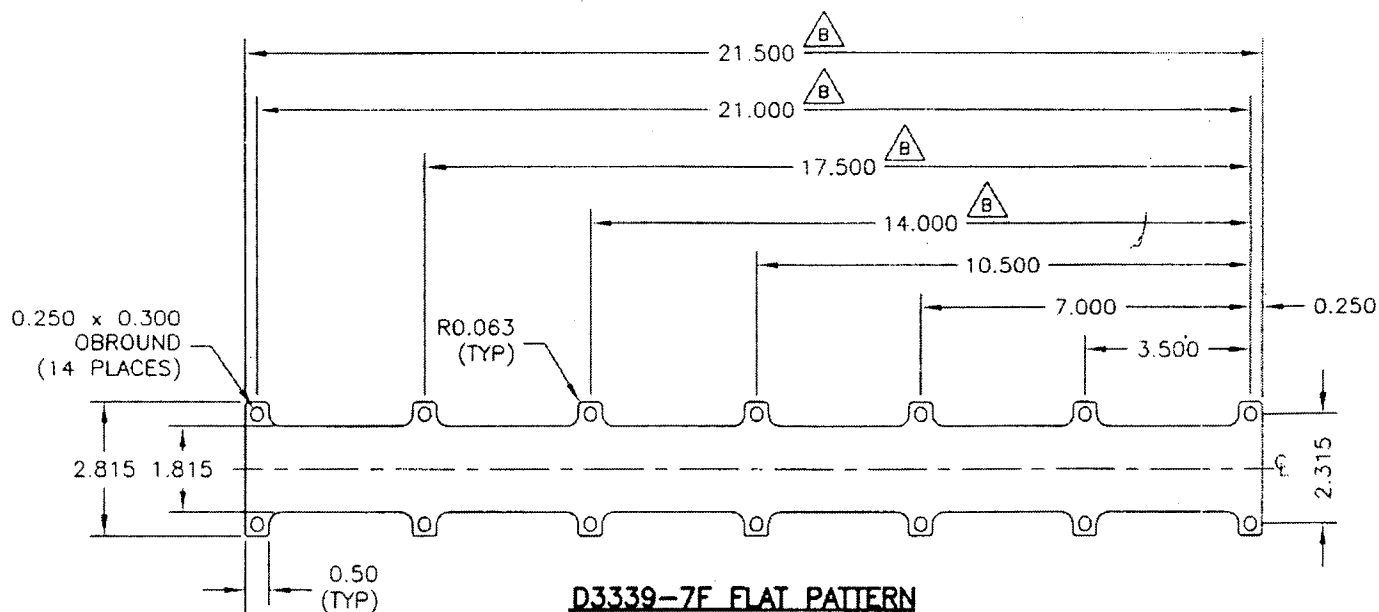
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:4

**NOTES:**

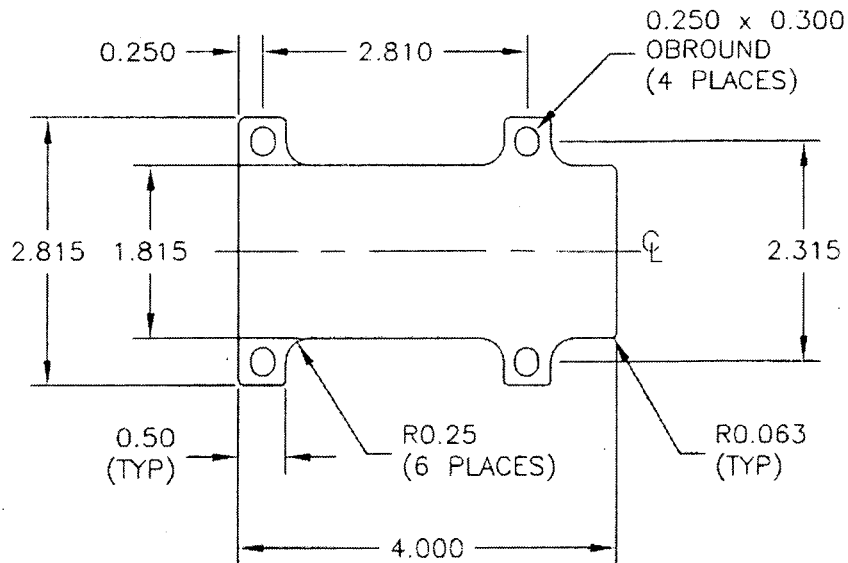
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
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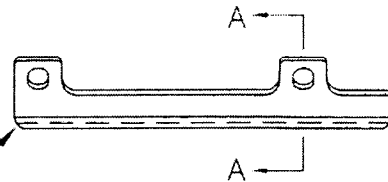
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DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:2

**D3339-9F FLAT PATTERN****RELEASED**
05.11.27 *[Signature]*

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-9T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-9 AFT WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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